

Date: Thursday, 10/11/2007 2:55:19 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : SHUT-OFF VALVE SHAFT

Job Number : 35141 -1

Estimate Number : 12181

P.O. Number : N/A

Part Number : D34691

This Issue : 10/11/2007

S.O. No. : N/A

Drawing Number : D3469 REV.A1

Prsht Rev. : NC

Project Number : N/A

First Issue : N/A

Type : PURCHASED PARTS

Drawing Revision : A1

Previous Run : 27012

Material : N/A

Due Date : 10/30/2007

Qty: 8 Um: Each

Written By :

Checked & Approved By :

Comment : est rev A 06.02.06 new issue EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M304S26GA

304/316 0.018 SHEET



Comment: Qty.: 0.8259 sf(s)/Unit Total : 6.6074 sf(s)

AISI 304/316 0.018 SHEET batch: M105490

mf 07-10-19

2.0

SHEAR

SHEAR



Comment: SHEAR

Cut flat pattern per dwg D3469 & Deburr if nessary

mf 07-10-18

3.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Drill holes and deburr as per dwg D3469

2-Roll sheet as per dwg D3469

3-Spot weld as per dwg D3469

4-Roll Bead as per dwg D3469

mf 07-10-22

4.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

SB 07/10/22

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
07/10/22	3	split u/o	SS	07/10/22	2			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ED Date: 07/10/23
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE SHAFT

Job Number: 35141

Part Number: D34691

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

MF

07-10-22

7.0

QC21

FINAL INSPECTION/W/O RELEASE



②

Comment: FINAL INSPECTION/W/O RELEASE

D0710/23

Job Completion

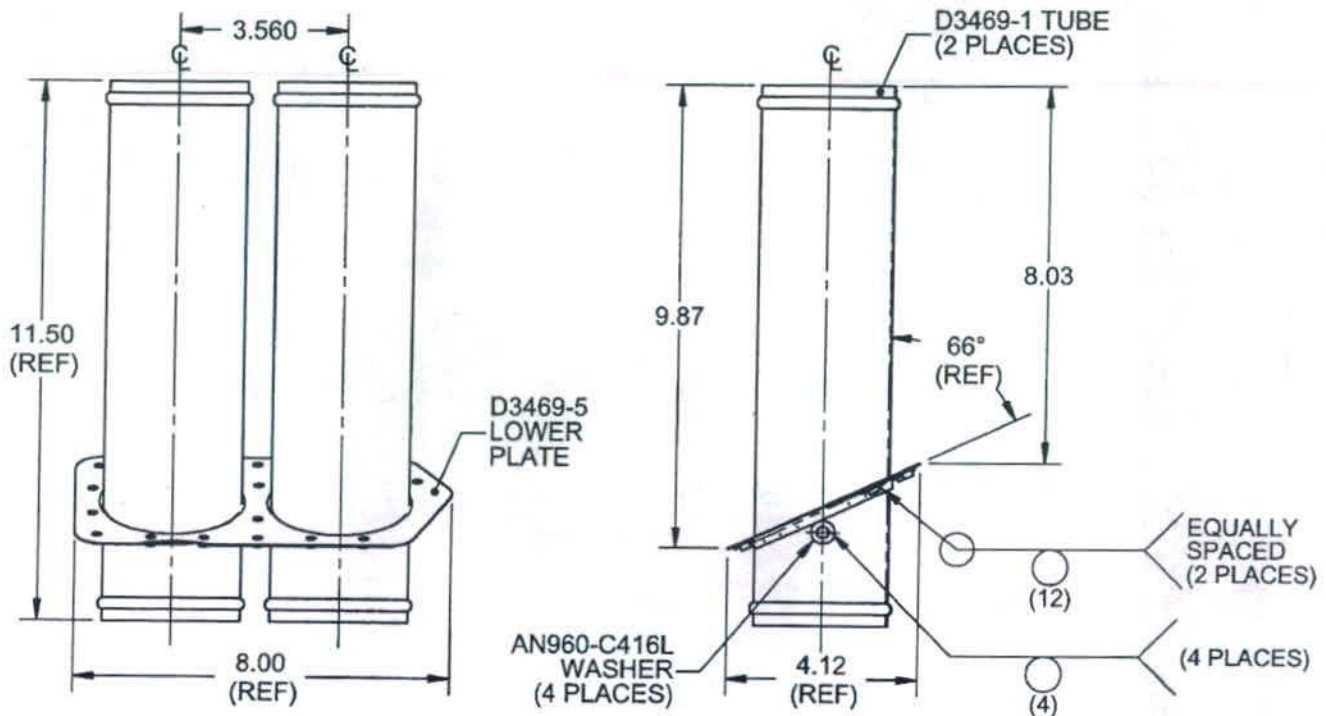


U 07.10.23

DART

DESIGN B	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3469	REV. A
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SHEET 2 OF 5 SCALE 1:4

06.04.03



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WITHOUT NOTICE
WORK ORDER
NO. 35141

D3469-043 TUBE ASSEMBLY**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

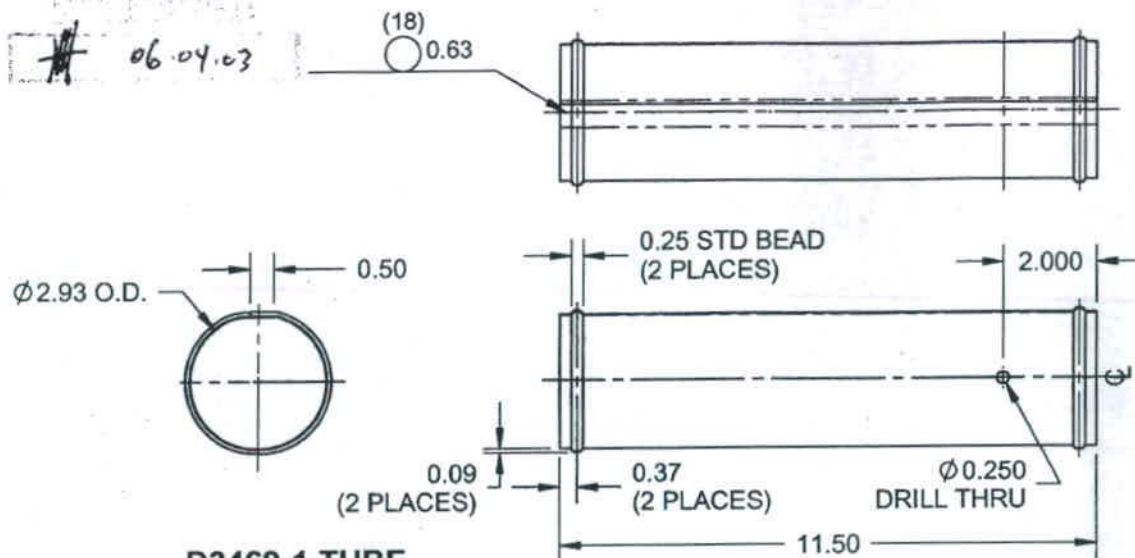
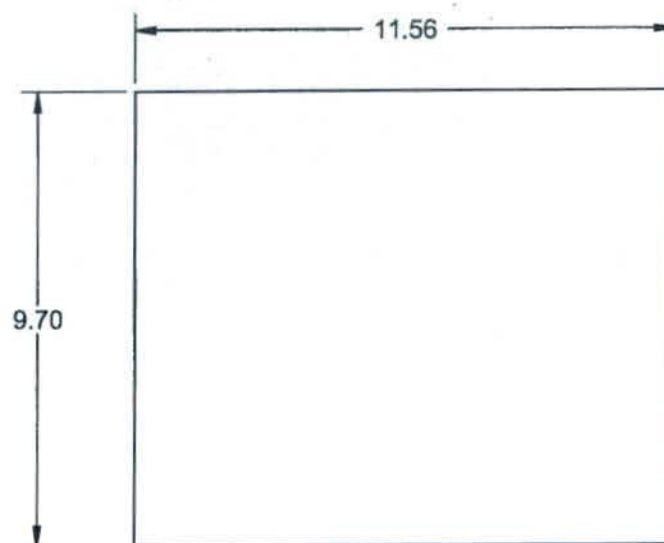
QTY -043	P/N	DESCRIPTION
X	D3469-043	TUBE ASSEMBLY
2	D3469-1	TUBE
1	D3469-5	LOWER PLATE
4	D3470-5	PLATE VALVE
4	AN960-C416L	WASHER

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DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3469	REV. A SHEET 3 OF 5
DATE 05.12.12		TITLE SHUT-OFF VALVE ASS'Y	SCALE 1:4

**D3469-1 TUBE****D3469-1F TUBE FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD
AMS-W-6858A
CLASS 'C'

TEST NO#: 28

EMPLOYEE: Melanie Fautour

PART NUMBER: D3469-1

JOB NUMBER: D 35141-1

MATERIAL TYPE: 304 L

MATERIAL THICKNESS: .019

GROUP SPECIFICATION

☐

Group 1: Aluminum & magnesium

☐

Group 2: Iron; nickel; cobalt

☒

Group 3: Titanium, SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<u>/</u>]	[]
PENETRATION:	[<u>/</u>]	[]
PULL STRENGTH:	[]	[]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/06/22
QUALIFIER: S/S

